

Work Order ID 156613***156613***

Page 1

Thursday, February 02, 2017 3:24:03 PM

Item ID: D3265-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Basket Base Assembly
Start Date: 2/28/2017 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 3/7/2017 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan:  Date: FEB 02 2017 Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3265	E

100 Weld per dwg A/R S.S. rod Batch: 136158 0.00***100***

Large Fab

Large Fab

Large Fab

Memo

0.00

1- Assemble and weld as per Dwg D3265 using DT9444

2- Deburr and remove all markings from material as required

3- weld mesh as per dwg

***IF MAKING A D350-607-045A, CUT OFF ON ONE SIDE D2327-3
SPACER AS PER IIN-D350-607-145 SHEET 15***/ MAR 11 2017DAS
24
9-89

110 QC9- Inspect visual per QSI004- Fusion Welds 0.00

110

QC

Quality Control

Memo

0.00

⑧ 11-03-13DAS
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FINISH TIME:

Work Order ID 156613

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Item ID: D3265-041 Accept ***N900040100*** Setup Start ***NS1***
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Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	QC3- Inspect Part Finish	0.00							
140									
QC	Memo	0.00							
Quality Control									
150		0.00							
150	Small Fab								
Small Fab	Memo	0.00							
Small Fab	Seal support gusset seam with White Sikaflex-291								
	Batch: <u>M136652</u>								
	Expiry date: <u>12/11</u>								
160	QC5- Inspect part completeness to step on W/O	0.00							
160									
QC	Memo	0.00							
Quality Control									

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MAR 20 2017

Work Order ID 156613

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Item ID: D3265-041 Accept ***N900040100*** Setup Start ***NS1***
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Start Date: 2/28/2017 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 3/7/2017 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	Identify as per dwg & Stock Location: <u>w/b</u>	0.00							
170									
Packaging	Memo	0.00							
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.02							
Quality Control									

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MAR 2 0 2017

Picklist Print

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Work Order ID: 156613

156613

Parent Item: D3265-041

D3265-041

Parent Item Name: Basket Base Assembly

Start Date: 2/28/2017

Required Date: 3/7/2017

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:C Re-Format 05-11-03 JLM
IPP Rev:D 08-09-10 revC as per dwg (ecn 08-524) DD verf: by:EC IPP
RevE: as per DEO DD 10.09.12 verified by:EC IPP RevF: revise seq
110 DD 10.01.28 verified by:EC IPP REV:G 12.07.26 AS PER
DWG REV.D DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2232-3		Manufactured	No			100	Each	18.0000	2	2			
D2232-3									**			CC 17-3-7	
Basket Hinge													

Location	Loc Qty	Loc Code
WA004	18	
141081	5	
143693	1	
148935	12	

✓ D2235-1
D2235-1
Basket Rib

Manufactured No 100 Each 4.0000 1

CC 17-3-7

Location	Loc Qty	Loc Code
WA004	4	
146357	3	
150136	1	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																																																										
Description Work Order Deviation				Disposition				Completed By																																																									
								Lead hand / Supervisor Approval Verification																																																									
								QC / QA Coordinator Approval																																																									
Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐																																																																

Picklist Print

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Work Order ID: 156613

156613

Parent Item: D3265-041

D3265-041

Parent Item Name: Basket Base Assembly

Start Date: 2/28/2017

Required Date: 3/7/2017

Start Qty: 1.00

Required Qty: 1.00

D2581

Manufactured No

100

Each

98.0000

2

2

D2581

Mounting Bracket

**

CC 17-3-7

Location

Loc Qty

Loc Code

WA004

98

132771

1

136270

2

139082

2

147603

2

148944

19

152803

48

155305

24

D3265-043

Manufactured No

100

Each

1.0000

1

D3265-043

Rib Assembly

**

CC 17-3-7

Location

Loc Qty

Loc Code

WA004

1

103623

1

D3265-1

Manufactured No

100

Each

5.0000

1

1

D3265-1

Rib

**

CC 17-3-7

Location

Loc Qty

Loc Code

WA004

5

100821

1

100821

4

D3265-5

Manufactured No

100

Each

0.0000

2

2

D3265-5

Rib

**

MAR 11 2017

DAS
24
9-89

B157815 → 2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
							Completed By		
							Lead hand / Supervisor Approval Verification		
							QC / QA Coordinator Approval		

Root Cause				FAULT CATEGORY			
Environment ☐	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐
Design ☐	☐	Operator	☐	Bending	☐	Set-up	☐
Doc/Data ☐	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐
Equip/Tooling ☐	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐
Handling/Pre ☐	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐
Material ☐	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐
Internal Transport ☐	☐	Poor Information	☐	Crushing	☐	Countersink	☐
Tribal Knowledge ☐	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐
LOA ☐	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐
Substation ☐	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐
Past Expiry Date ☐	☐	Manufacturing Process	☐	OTHER : _____			
Misidentified ☐	☐	Past Due	☐				

Picklist Print

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Work Order ID: 156613

156613

Parent Item: D3265-041

D3265-041

Parent Item Name: Basket Base Assembly

Start Date: 2/28/2017

Required Date: 3/7/2017

Start Qty: 1.00

Required Qty: 1.00

✓ D3442-5

Manufactured No

100

Each

27.0000

4

4

D3442-5

Shim

**

CC 17-3-7

Location

Loc Qty

Loc Code

WA004

27

100959

3

113158

24

3x

1x

D3825-041

Manufactured No

100

Each

8.0000

2

2

D3825-041

Rib Assembly (Basket End)

**

CC 17-3-7

Location

Loc Qty

Loc Code

WA004

8

148770

8

2x

✓ D3826-041

Manufactured No

100

Each

6.0000

2

2

D3826-041

Rib / Gusset Assembly

**

CC 17-3-7

Location

Loc Qty

Loc Code

WA004

6

150219

6

2x

✓ D3832-11

Manufactured No

100

Each

0.0000

1

1

D3832-11

Mesh (Base)

*B 157804 → 1x ***

CC 17-3-7

✓ D3833-1

Manufactured No

100

Each

14.0000

2

2

D3833-1

Mesh (Base End Face)

**

CC 17-3-7

Location

Loc Qty

Loc Code

WA006

14

146407

6

149792

8

2x

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Shop Packet Print

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DQA: _____ Date: _____



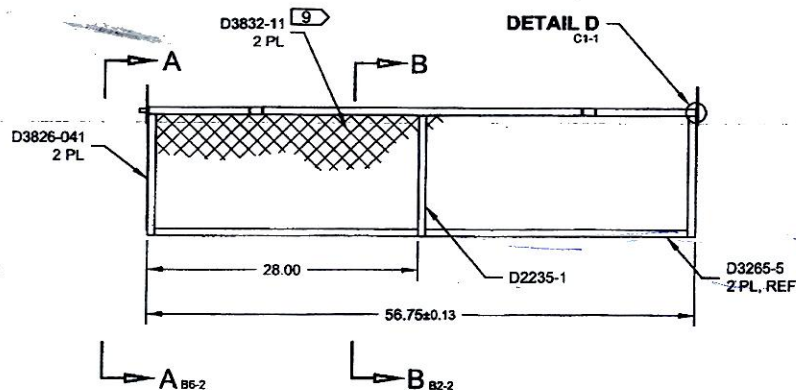
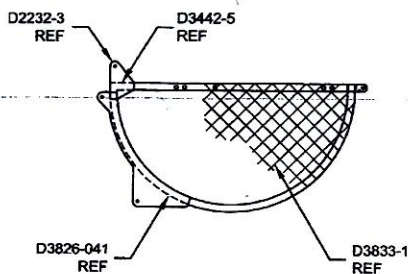
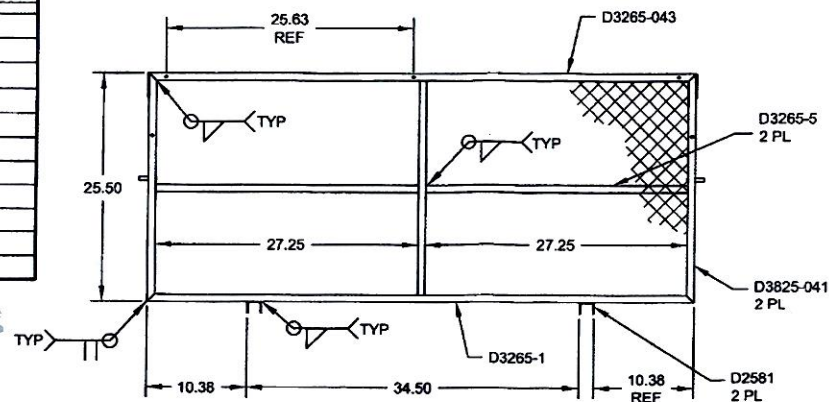
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

QTY -041	PART NUMBER	DESCRIPTION
X	D3265-041	BASKET BASE ASSY
2	D2232-3	HINGE PLATE
1	D2235-1	RIB
2	D2581	MOUNTING BRACKET
1	D3265-1	RIB
1	D3265-043	RIB ASSY
2	D3265-5	RIB
4	D3442-5	SHIM
2	D3825-041	RIB ASSY
2	D3826-041	RIB/GUSSET ASSY
1	D3832-11	MESH (BASE, SM)
2	D3833-1	MESH, BASE END FACE



D3265-041 BASKET BASE ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) WELD PER DART QSI 004
- 9) SKIN INSIDE SURFACE OF BASKET WITH D3832-11, TACK WELD EACH END OF STRAND TO FRAME

SHOP COPY

**RETURN TO
ENGINEERING**

**UNCONTROLLED COPY
SUBJECT TO AMENDMENT**

**WITHOUT NOTICE
WORK ORDER**

**NO. 156613
FEB 02 2017**

**DETAIL D C4-1
(BOTH ENDS)
SCALE 10X**

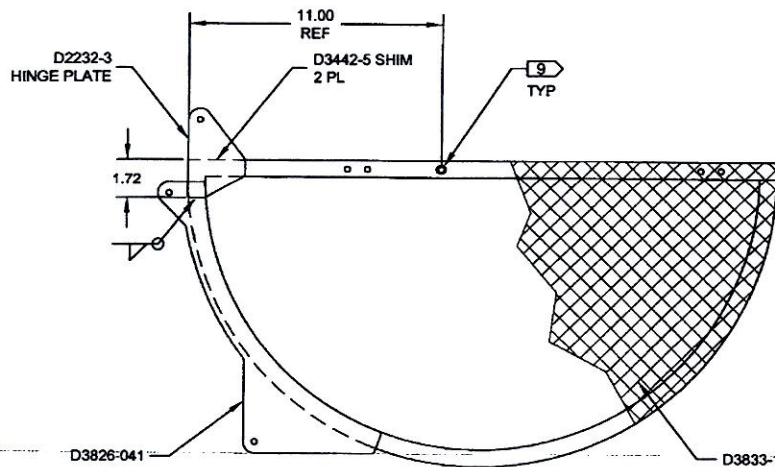
RELEASED
2012-08-03

E	CORRECTED 53.25 DIM SHIFED AT LAST REV (ZNC3-3).	MB	12.07.26
D	REVISED PARTS LIST: QTY(2) D3826-041 REPLACE QTY(4) D2325 & QTY(2) D2235-1; QTY(1) D3265-043 REPLACES QTY(1) D3265-1; QTY(4) D3442-5 WAS QTY(2); REMOVE D3265-3 ADD D3265-7; D3825-041 WAS D3265-3; CREATED D3265-043; ADDED D3832-11 AND D3833-1. REASON: PAR10-50.	MB	12.05.14
C	DRAWING UPDATED TO CURRENT STANDARDS. SHT 4 ADDED. RIB MATERIAL WAS 0.060 THICK. SHT 2 ZONE D5 25.63 DIMENSION WAS 27.63.	AJS	08.08.14
B	INCORPORATED A1. ADD SHIM UNDER HINGES. ADD HOLES FOR SPLIT LID BASKETS.	PH	05.06.08
A	NEW ISSUE	CP	04.02.02
REV.	DESCRIPTION	BY	DATE
DESIGN	DS		
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	12.07.26		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3265
REV. E
SHEET 1 OF 3
TITLE BASKET BASE ASSEMBLY (350)
SCALE NTS

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SECTION A-A 66-1
2 PL
(BOTH END RIBS)



SECTION B-B 85-1
2 PL
(BOTH CENTER RIBS)

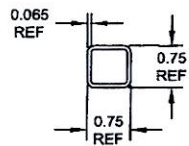
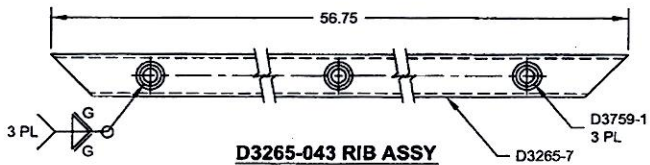
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) WELD PER DART QSI 004
- 9) TRIM EXPANDED METAL LOCALLY AS REQUIRED, TYP BOTH ENDS

RELEASED
2012-08-03
JMP

DESIGN	DS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D3265	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (350)	NTS
DATE	12.07.26	COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS ISSUED AND CONSIDERED AS SUPPLIED ON THE CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

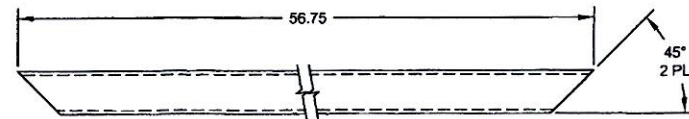
QTY -043	PART NUMBER	DESCRIPTION
X	D3265-043	RIB ASSY
1	D3265-7	RIB
3	D3759-1	BUSHING



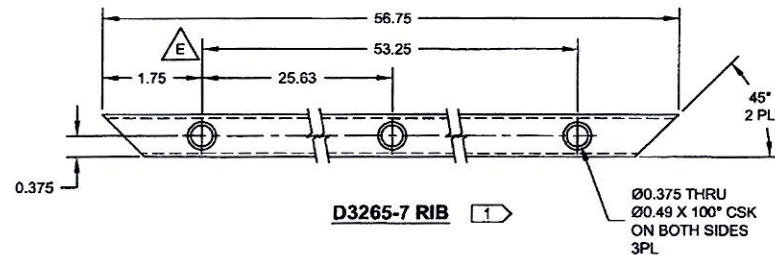
TYP SECTION

NOTES:

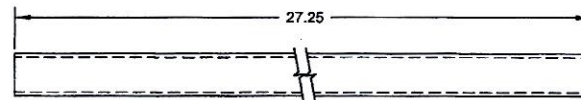
- 1) MATERIAL: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBING
PER ASTM A554/A269 MILL FINISH, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC M304TS0.750W.065
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) WELDING: PER DART QSI 004



D3265-1 RIB



D3265-7 RIB



D3265-5 RIB 

RELEASED
2012-08-03
WJ

DESIGN	DS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG APPR.		D3265	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (350)	
DATE	12.07.26	NTS	

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